

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-64 Date Opened: 04-Jun-15 Title: AssemblyAircraft OEM: Robinson Aircraft Model: R44 Product Type: Cargo Basket Product Model: Standard Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
90610	0	Basket	JR
90611	0	Body	JR
90612	0	Lid	JR
90627	0	Data Card	JR

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

N/A
MR
MR
MR
MR
MR
MR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Note:

Basket is stainless steel - for display purposes only. No release certificate.

Work performed by:

Print: J. Rekve for M. RekveSign: [Signature]SCA: AD01Date: 04-Jun-15

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 04-Jun-15

Work Order closed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 04-Jun-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

CARGO BASKET ASSEMBLY - COMMON

SP 90601-16

Complete
(initial or SCA #)

Work Order: 2015-64 Stainless

Date Open: 4 Jun 15

OK

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

OK

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.



4. Install Handle

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
 - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - At first end, remove bolt and repeat step iv.
 - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
 - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.



5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

He.

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2015-64Date Opened: 04-Jun-15Material Tracking Sheet
Robinson R44
Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			90610-01-	Cargo Basket Assembly	(-01 RH, -02 LH)	
Step 1				<i>Lid Assembly</i>		
	. 1		90612-01-	Basket Lid Assembly		
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		90627-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		90611-01-	Basket Body Assembly		
	. . 3		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 1		90628-01	Fitting		
	. . 8		NAS1149F0663P	Washer		
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	54"	
	. 8		CR3523-5-02	Cherry Rivet		
	. A/R		CR3213-5-02	Cherry Rivet		
Step 4	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		
Step 4.b.	. . 1		84261-01	Handle Assembly		
	. . 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	. . 2		36275-01	Bushing	Brass, 5/16" Dia	
	. . 2		AN3-12A	Bolt		
	. . 4		NAS1149F0363P	Washer		
	. . 2		MS21044N3	Nut		

Work Order: _____

Date Opened: _____

Material Tracking Sheet
Robinson R44
Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 5				<i>Lid Brace Installation</i>		
	. 1		36280-01	Brace Assembly		
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				<i>Inspection</i>	<i>None</i>	

Aero Design

Parts Distribution Sheet

S/S R44

W2 2015-64

WO# _____

[illegible]

25.0

[illegible]

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100

1

Figure 1

1971-72

1990

20

10

Schizothorax

1970-1971

1000

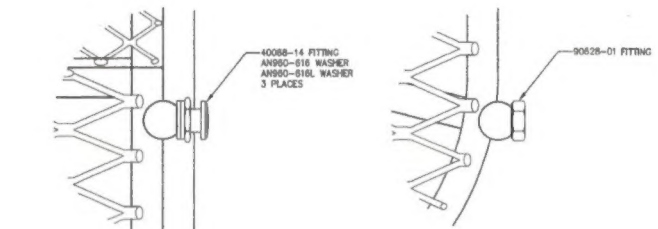
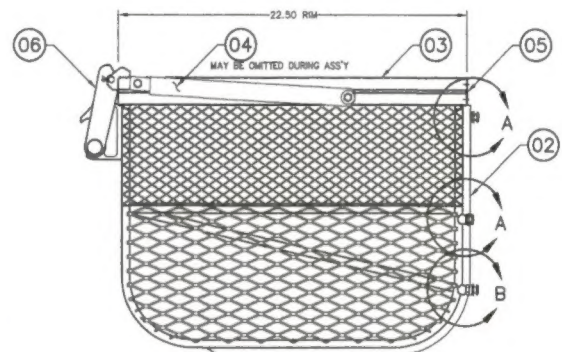
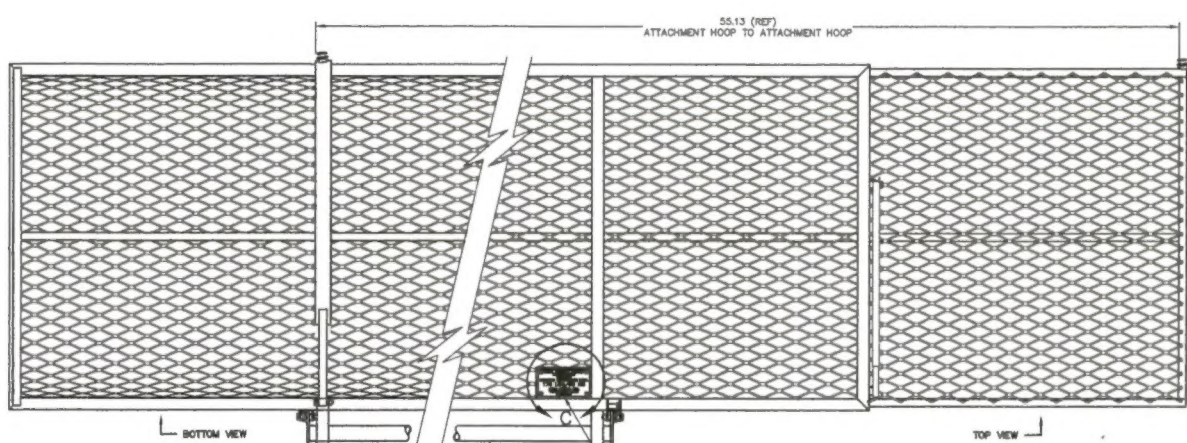
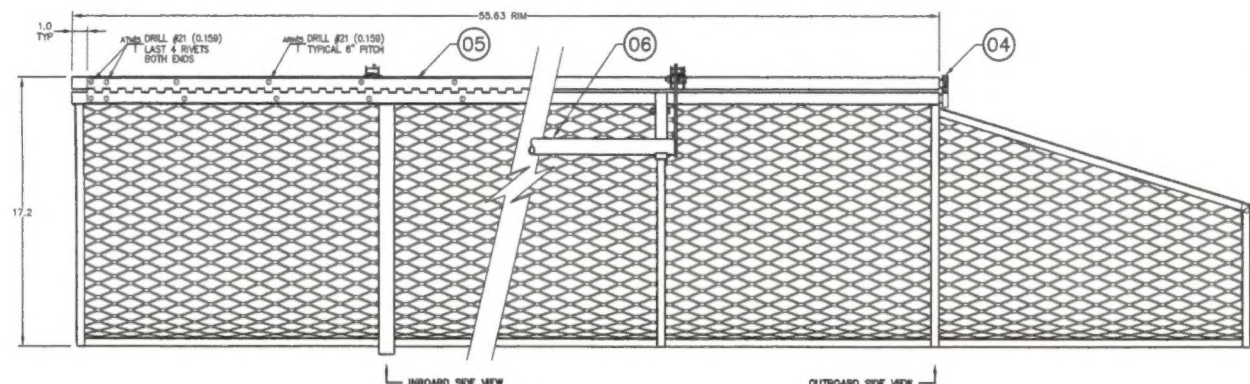


(continued)

$\frac{d}{dt} \left(\frac{\partial L}{\partial \dot{x}} \right) = \frac{\partial L}{\partial x}$

2015-64

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



DETAIL A

SCALE 1 : 1
FRONT TOP AND REAR TOP AND BOTTOM POSITIONS

DETAIL B

SCALE 1 : 1
FRONT BOTTOM POSITION ONLY

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

A/R/A/R	AN980-610L	WASHER		
A/R/A/R	AN980-610	WASHER		
1	1	90626-01	FITTING	
3	3	40088-14	FITTING	ANCHRA
8	8	CR3213-5-02	CHERRY RIVET	
A/R/A/R	CR3213-5-02	CHERRY RIVET		
4	4	CR3213-4-02	CHERRY RIVET	
3	3	48205-14	08 BUMPER	ARGUS INDUSTRIES
1	1	90627-02	07 PLACARD	
1	1	90627-01	07 PLACARD	
1	1	84255-01	08 HANDLE BAR INSTALLATION	
1	1	MS2000IP4	05 PLANO HINGE	53.5 LONG
1	1	36280-01	04 BRACE ASSEMBLY	
1	1	90812-01-02	03 BASKET LID ASSEMBLY (LEFT HAND)	
1	1	90812-01-01	03 BASKET LID ASSEMBLY (RIGHT HAND)	
1	1	90811-01-02	02 BASKET BODY ASSEMBLY (LEFT HAND)	
1	1	90811-01-01	02 BASKET BODY ASSEMBLY (RIGHT HAND)	
1	1	90810-01-02	01 CARGO BASKET ASSEMBLY (LEFT HAND)	
1	1	90810-01-01	01 CARGO BASKET ASSEMBLY (RIGHT HAND)	
-02	-01	PART NO.	ITEM	
QTY				
90810-01				

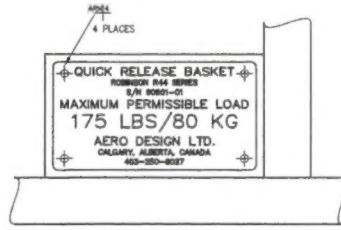
LIST OF MATERIALS

BASIC CODE REF. HAS 523		DASH NO. FOR DIAMETER R=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGOIN		DATE 13 SEPT 2010		COST OF MATERIALS	
C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES OR: DECIMALS ANGLES		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DLR 200 3013 – 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA. TEL 800 TEL (403) 260-9597 FAX (403) 260-9598 www.aerodesign.ca			
BASIC CODES: BJ=MS20470AD BB=MS20426AD AR=CR3213 ATM=CR3523		<div> <div>+</div> <div>+</div> <div>+</div> </div> <div> <div>+</div> <div>+</div> <div>+</div> </div> <div> <div>+</div> <div>+</div> <div>+</div> </div>		<div> <div>+</div> <div>+</div> <div>+</div> </div> <div> <div>+</div> <div>+</div> <div>+</div> </div> <div> <div>+</div> <div>+</div> <div>+</div> </div>		<div> <div>+</div> <div>+</div> <div>+</div> </div> <div> <div>+</div> <div>+</div> <div>+</div> </div> <div> <div>+</div> <div>+</div> <div>+</div> </div>		ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY	
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INSTALL NEW RIVET

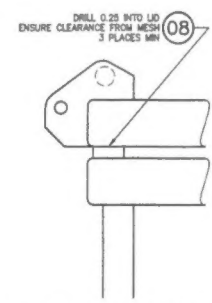
REMOVE/REPLACE RIVET

EXISTING RIVET



DETAIL C

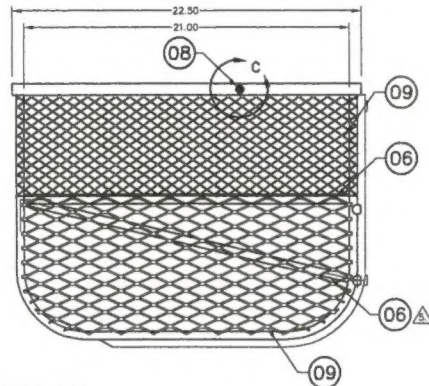
SCALE 1 : 1
LOOKING AT PLACARD BRACKET



BUMPER INSTALLATION

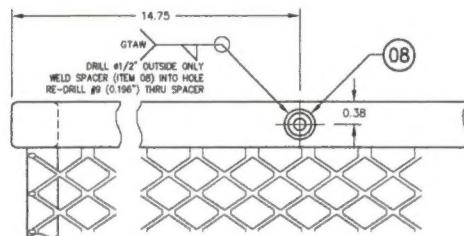
SCALE 1 : 1

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES:

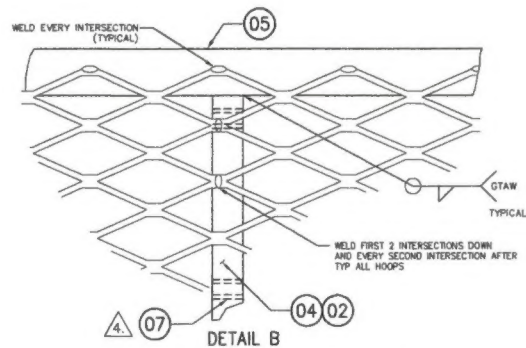
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. PRIOR TO WELDING, DRILL 3/32 VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2883C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. INSTALL ITEM 7 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 TYP 2 PLACES.
5. STRUT MEMBER ON FWD END OF BASKET ONLY.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.



DETAIL C

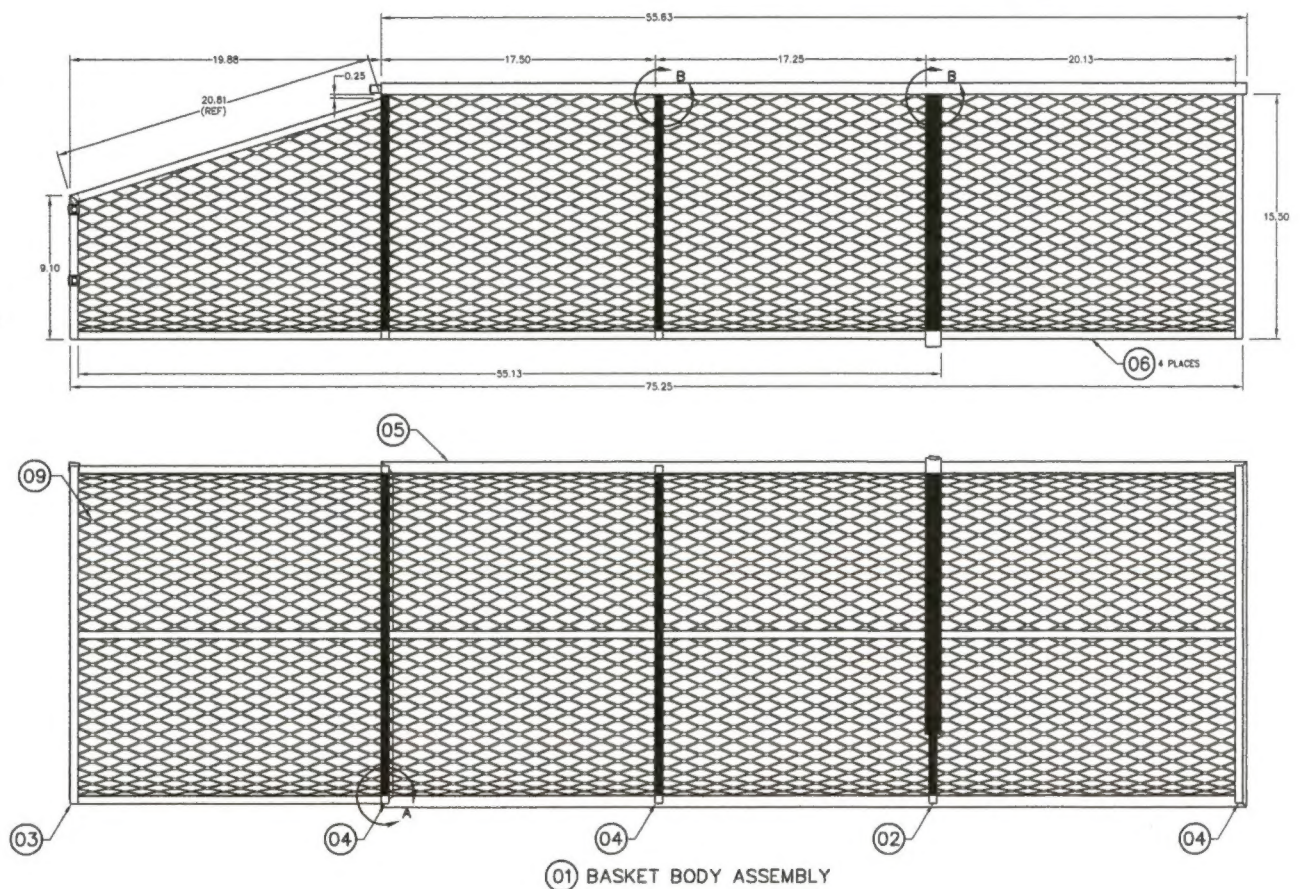
SCALE 1:1

VIEW LOOKING AT FRONT RIM OF BASKET

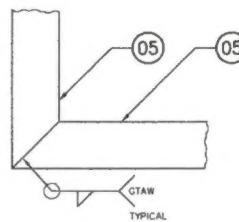


DETAIL B

SCALE 1:1
VIEW LOOKING AT INNER SURFACE OF BASKET, OUTBOARD SIDE



01 BASKET BODY ASSEMBLY

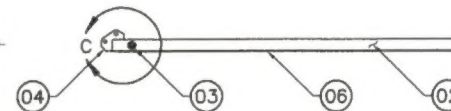
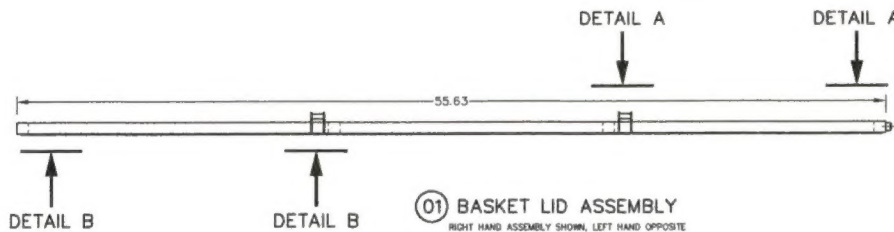
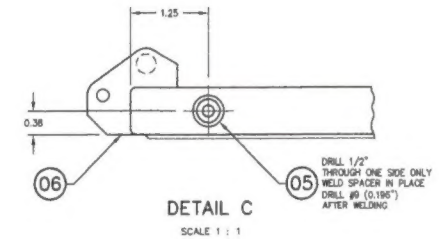
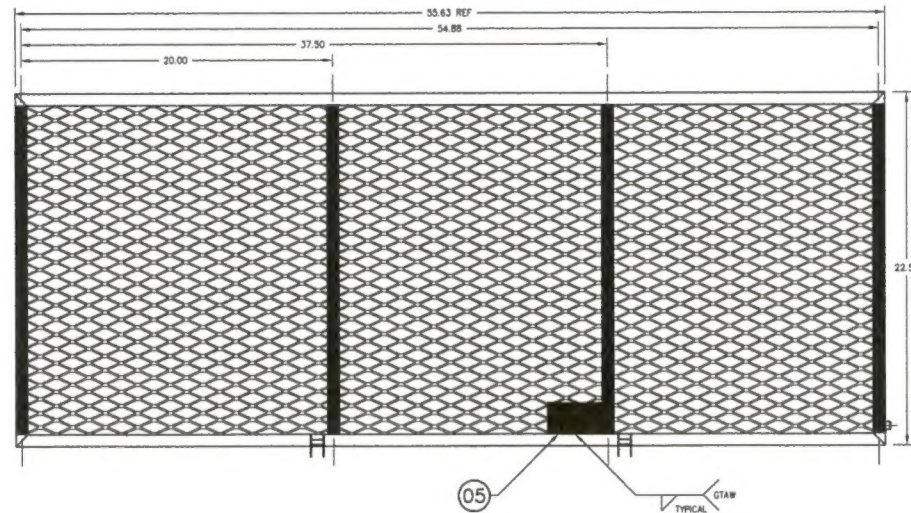


DETAIL A

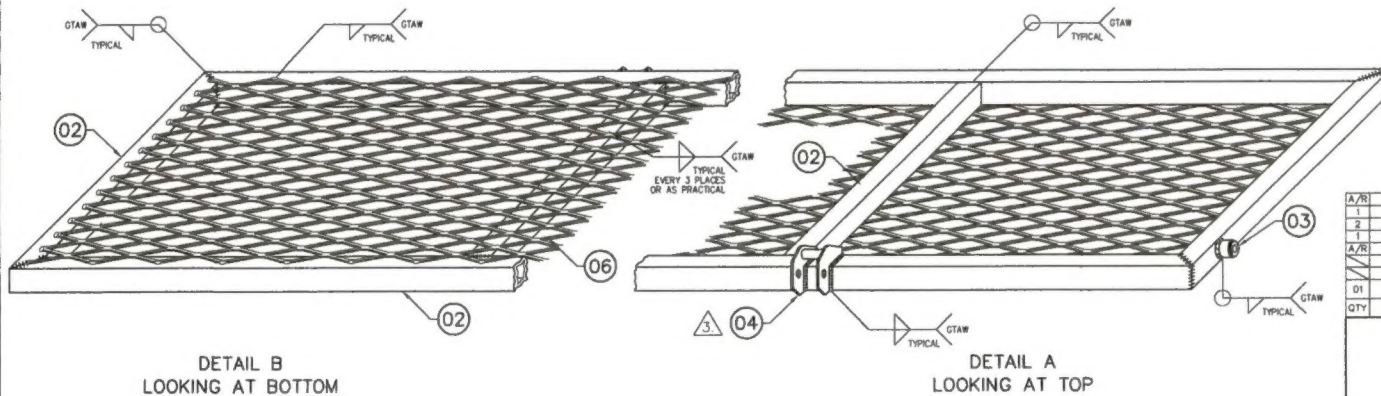
SCALE 1:1

A/R/A/R	3/4-16F	09	MESH	STEEL	COMMERCIAL		
1	1	49215-01	08 SPACER				
1	1	84262-01	07 HANDLE BRACKET ASSEMBLY				
A/R/A/R	06	TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR. TUBE		
A/R/A/R	03	TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR. TUBE		
3	3	49210-02	04 HOOP				
1	1	90522-01-02	03 FORWARD ATTACHMENT HOOP (LEFT HAND)				
1	1	90522-01-01	03 FORWARD ATTACHMENT HOOP (RIGHT HAND)				
1	1	90521-01-02	02 AFT ATTACHMENT HOOP (LEFT HAND)				
1	1	90521-01-01	02 AFT ATTACHMENT HOOP (RIGHT HAND)				
1	1	90611-01-02	01 BASKET BODY ASSEMBLY (LEFT HAND)				
1	1	90611-01-01	01 BASKET BODY ASSEMBLY (RIGHT HAND)				
-02	-01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY						
LIST OF MATERIALS							
APPROVALS				DATE			
DRAWN: JEFF CLARKE				03 SEPT 2010			
CHECKED: E. BURGOIN							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:							
DECIMALS				ANGLES			
X.XXX ±0.010				±1/2°			
X.XX ±0.03							
X.X ±0.1							
AERO DESIGN LTD.							
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M							
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 8B7							
tel: (403) 250-8087				fax: (403) 250-8583		www.aerodesign.ca	
ROBINSON R44, R44 II							
QUICK RELEASE CARGO BASKET							
BASKET BODY ASSEMBLY							
SCALE 1 : 4				DWG. NO.		REV.	
SHEET 1 OF 1				A1		90611 0	

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(01) BASKET LID ASSEMBLY
RIGHT HAND ASSEMBLY SHOWN, LEFT HAND OPPOSITE



DETAIL B
LOOKING AT BOTTOM

DETAIL A
LOOKING AT TOP

- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C.
 3. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 4. INSTALL ITEM 4 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 TYP 2 PLACES.
 5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

A/R	3/4-16F 06	MESH					
1	36204-10 05	PLACARD BRACKET					
2	84262 04	UPPER HANDLE BRACKET ASSY					
1	49216-01 03	SPACER					
A/R	-- 02	TUBE	4130 STEEL, COND. N	MIL-T-8736	0.75 X 0.035 SQR	TUBE	
90812-01-02	01	BASKET LID ASSEMBLY (LEFT HAND)					
90812-01-01	01	BASKET LID ASSEMBLY (RIGHT HAND)					
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY							
LIST OF MATERIALS							
AERO DESIGN LTD.							
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 290M 2015 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 0R7 Tel: (403) 296-8627 Fax: (403) 255-6332 www.aerodesign.ca							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:							
DECIMALS ANGLES							
X.XXX ±0.010 ±1/2°							
X.XX ±0.03							
X.X ±0.1							
ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET BASKET LID FABRICATION							
SCALE 1 : 4				DWG. SIZE		DWG. NO.	
SHEET 1 OF 1				A1		90612	
						0	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"ROBINSON R44 SERIES" - 0.080 HIGH
"S/N 90601-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"175 LBS/80 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

- ON 90627-02: S/N IS 90602-XX.

DRILL #30 (0.129)
4 PLACES



01 PLACARD
02 PLACARD

90627-02	02	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
90627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET PLACARD			
	SCALE 1 : 1		DWG. SIZE A1	DWG. NO. 90627	REV. 0	
	SHEET 1 OF 1					